

5/30

65.

DART AEROSPACE LTD	Work Order:	23620
Description: Support Assembly	Part Number:	D3278-041
Dwg: D3278 Rev. A <i>BC 105-06-07</i>	Qty:	38 <i>4Q</i> Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <i>TP</i> <i>Dwg NOT REQUIRED 04.07.05</i>	<i>PF</i>	05.06.21	40
2	MV	Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Identify for D3278-1	<i>EP</i>	05.07.14	40
3	MV	Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Identify for D3278-2	<i>CP</i>	05.07.14	40
4	MV	Machine D3278-1 as per Folio FA405 and Dwg D3278 Identify as D3278-1	<i>EP</i>	05.07.15	40
5	QC2	Inspect parts as they come off the CNC machine	<i>EP</i>	05.07.15	40
6	MV	Deburr and Tumble	<i>EP</i>	05.07.15	40
7	QC8	Second check	<i>EP</i>	05.07.16	40
8	MV	Machine D3278-2 as per Folio FA405 and Dwg D3278 Identify as D3278-2	<i>EP</i>	05.07.16	40
9	QC2	Inspect parts as they come off the CNC machine	<i>EP</i>	05.07.16	40
10	MV	Deburr and Tumble	<i>EP</i>	05.07.16	40
11	QC8	Second check	<i>EP</i>	05.07.16	40
12	FP	Acid etch and Alodine as per QSI 005 4.1	<i>SAD</i>	05.08.11	40
13	QC5	Inspect work to Step 12	<i>Z</i>	05.08.14	40
14	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	<i>ML</i>	05.09.10	40
15	QC3	Inspect Powder Coat	<i>SB</i>	05.09.21	40
16	GA	Rivet spacers with support as per Dwg D3278. (Note: D3278-1/-2 are on BOM as material from Steps 2-3) Pick: Packing Kit			
		Qty Part Number Description Batch			
		1 D3278-1 Support <i>A 23620</i>			
		1 D3278-2 Support <i>B 23620</i>			
		1 D3278-3 Spacer <i>B 22971</i>			
		4 MS20426AD3-07 Rivet <i>H 17694</i>			
17	QC5	Inspect work to Step 16	<i>Z</i>	05.09.22	38

RELEASED

04.04.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/07/15	# 4	3 pants (D3278-1) scraps set up problems (ED)	ED 05/07/15	Fixed problems Scrap + Replace	ED 05/07/15	SB 05/07/19	ED 05/07/19	SB 05/07/19
05/09/22	16	removed rivet MS 2042 & AD 4-7 because were to long + part hole was over tolerance	SB 05/09/22	Scrap.	SB 05/09/22	SB 05-09-22	SB 05/09/22	SB 05-09-22

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: SB Date: 05/09/22

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD	Work Order:	23620
Description: Support Assembly	Part Number:	D3278-041
Dwg: D3278 Rev. A <i>APL JH 5.06.01</i>	Qty:	40

Page 2 of 2

Step	Location	Procedure	By	Date	Qty
18	GA	Assemble support as per Dwg D3278 Pick: Packing Kit Qty Part Number Description Batch 2 D2230-1 Clamp <i>B22163e</i> 2 AN4-13A Bolt <i>M17404</i> 4 AN960JD416 Washer <i>M175166</i> 2 MS21042L4 Nut (or -4) <i>M15924</i>		<i>SB 05/09/20</i>	38
		<i>Identify as D3278-041 Do NOT Tighten Bolts.</i>			
19	QC5	Inspect work to Step 18		<i>205-05-26</i>	38
20	ST	Identify and Stock		<i>CD 05/09/26</i>	38
21	AC	Cost / part <i>61.17</i>		<i>545-05-09-29</i>	38
22	DC	Close W/O <i>55.94</i> Inspect Level 21		<i>TP 05/09/27</i>	38

Rev	Date	Change	Revised By	Approved
A	04.04.19	New issue	KJ/JLM	<i>205-04-22</i>

RELEASED

*205-04-22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	23620
Description:	Support	Part Number:	D3278-1
Inspection Dwg:	D3278	Rev:	B

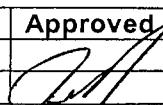
Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.098	—			
0.359	+/-0.005	0.356	—			
0.618	+/-0.010	0.618	—			
0.250	+/-0.010	0.250	—			
1.480	+/-0.005	1.480	—			
R0.125	+/-0.010	0.125	—			
0.119	+0.005/-0.004	0.118/0.120	—			
2.439	+/-0.010	2.435	—			
1.980	+/-0.010	1.985	—			
R0.130	+/-0.010	0.130	—			
Ø0.257	+0.005/-0.000	0.257	—			
R0.375	+/-0.010	0.375	—			
0.875	+/-0.010	0.873	—			
0.500	+/-0.010	0.504	—			
R0.400	+/-0.010	0.400	—			
1.720	+/-0.010	1.725	—			
R0.125	+/-0.010	0.125	—			
0.125	+/-0.010	0.128	—			

Measured by:	EP	Audited by:	9M	Prototype Approval:	N/A
Date:	05/07/14	Date:	05/07/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	

RELEASED  
05/06/08

DART AEROSPACE LTD		Work Order:	23620
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278	Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.098	—			
0.359	+/-0.005	0.350	✓			
<del>0.675</del> 0.609	+/-0.010	0.613	—			
0.250	+/-0.010	0.250	—			
1.480	+/-0.005	1.481	—			
R0.125	+/-0.010	0.125	✓			
0.119	+0.005/-0.004	0.120	✓			
2.439	+/-0.010	2.441	—			
1.980	+/-0.010	1.985	—			
R0.130	+/-0.010	0.130	—			
Ø0.257	+0.005/-0.000	0.257	—			
R0.375	+/-0.010	0.375	✓			
0.875	+/-0.010	0.873	—			
0.500	+/-0.010	0.499	—			
R0.400	+/-0.010	0.400	—			
1.720	+/-0.010	1.728	✓			
R0.125	+/-0.010	0.125	✓			
0.125	+/-0.010	0.127	✓			

Measured by:	<i>ES</i>	Audited by:	<i>BG</i>	Prototype Approval:	N/A
Date:	05/07/15	Date:	05.07.15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	<i>[Signature]</i>
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	<i>[Signature]</i>

**RELEASED**  
05/07/2015

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 20, 2005  
03:23 pm

Work Order No : 0023620  
 Project Name : D3278-041  
 Project For : WK530  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3278-041  
 Description : Support Assembly  
 Manufactured : Yes  
 Amount Req'd : 40  
 Amount Done : 0  
 Start Date : 06-20-05  
 Est Finish Date : 07-30-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00